

Title (en)

Apparatus and method for one side welding of curved steel plates

Title (de)

Verfahren und Vorrichtung zum einseitigen Schweißen von aus Stahl hergestellten gewölbten Werkstücken

Title (fr)

Méthode et appareil pour souder d'un côté des tôles d'acier courbes

Publication

EP 0855240 B1 20040407 (EN)

Application

EP 98101314 A 19980126

Priority

JP 1268297 A 19970127

Abstract (en)

[origin: EP0855240A1] An X travelling carriage Y1; a Y travelling carriage 4 supported thereon; a base 2 depending therefrom and supported to be rotatable about a vertical axis Z; a mechanism 12 for driving the base for elevating motion in the direction Z; a θ turning mechanism 10 for driving the base for rotation about the axis Z; a dual axis potentiometer P3 supported by the base 2 for detecting a Z-position and an offset in the θ direction of the groove; a dual potentiometer P2 located forwardly of the potentiometer P3 for similarly detecting the Z-position and the offset in the θ direction of the groove; and welding torches 30L, 30T supported by the base for welding the groove are provided. An angle of bending in the θ direction as well as an angle of inclination alpha in the fore-and-aft direction of the groove are calculated in accordance with detection values from P2 and P3. The base 2 is driven for turning motion in the θ direction and for elevating motion in the Z direction in accordance with these angles. A torch angle gamma adjusting mechanism M7 automatically adjusts gamma in accordance with the angle of inclination alpha. An angle of inclination beta of works in lateral direction is detected by potentiometers P5 and P4, thereby adjusting the center position of oscillation. A groove angle from 30 DEG to 65 DEG is chosen. A backing is applied to the rear surface of the groove, and the groove is filled with steel particles or iron powder to an elevation from one-quarter to two-thirds the plate thickness. A leader welding electrode wire is oscillated with a frequency from 40 to 150 cycles per minute while a follower welding electrode wire is oscillated at a frequency from 30 to 120 cycles per minute. A welding current density is equal to or greater than 200 A/mm<2> for the leader electrode and is equal to or greater than 150 A/mm<2> for the follower electrode, and the inter-electrode spacing between the leader and the follower electrode is chosen from 100 to 600 mm for the welding operation. <IMAGE>

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IPC 8 full level

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CPC (source: EP)

B23K 9/1278 (2013.01); **B23K 2101/18** (2018.07)

Citation (examination)

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